

Work Order ID 63456

December 16, 2010 1:40:27 PM



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Item ID: D205-770-011

Accept



Setup Start



Revision ID:

Item Name: Replacement Engine Mount

Stop



Start Date: 11/02/10 Start Qty: 1.00



Cust Item ID:

Required Date: 11/05/10 Req'd Qty: 1.00



Customer:

Reference: RA110095 - RETURN

Approvals:

Process Plan:

W

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN D205-770

Rev C

MDL-D205-770

E

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

Inspect RA110095

8/10/12/20

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Item Name: Replacement Engine Mount

Start Date: 11/02/10 Start Qty: 1.00

Cust Item ID:

Required Date: 11/05/10 Req'd Qty: 1.00

Customer:

Reference: RA110095

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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121

0.00



Small Fab

Memo

0.00

Small Fab

CLEAN PARTS WITH WASH & WIPE,
REAPPLY ANTI-SEIZE.
RE-DRILL D3684-041 TO .187

DISCARD ALL USED HARDWARE

RETURN ALL PARTS TO STOCK

(LPZ PNC2086 4.1.1 (Asme 1417 level 2))

NDT D3684-041 per Dwg.

plg D3687 - 1 + D3688 - 3

P/O: 13250

And relin.

clean re-assembly completely

SB 11/01/12

CZ 11/01/10 x2

11/01/08 (2)

122

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sub 12

(H)

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Customer:



Reference: RA110095

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Packaging	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	RETURN PARTS TO STOCK, USING ORIGINAL B/N DO NOT STOCK KIT, PARTS ONLY								
140  QC	QC21- Final Inspection - Work Order Release	0.00							
Quality Control	Memo	0.00							

returned to stock

D3686-041 BS4877
D3685-041 BS4878
D3686-041 BS4877
D3684-043 BS8201

11/1/12

W 1101-13

Picklist Print

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Work Order ID: 63456

Parent Item: D205-770-011

Parent Item Name: Replacement Engine Mount

Start Date: 11/02/10

Required Date: 11/05/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue ECN1165p 08-03-31 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D205-770-011 Replacement Engine Mount		Manufactured	No				Each	0.0000		1			
D3684-043 MOUNT ASSEMBLY		Manufactured	No				Each	0.0000	1	-1			
D3684-045 LEG ASSEMBLY		Manufactured	No				Each	0.0000	1	-1			
D3685-041 BIPOD MOUNT ASSEMBLY		Manufactured	No				Each	0.0000	1	-1			
D3686-041 MONOPOD ASSEMBLY		Manufactured	No				Each	0.0000	1	-1			

D3692-3
 Kept Spacer D3692-1
 AW3C12A B 116289
 MS21043-3 A 112314
 AN3C10A M105940
 D3693-3 B50723

qty 20
 qty 22
 qty 2
 qty 1

SB 11/01/12

/

B55202 8/1/13

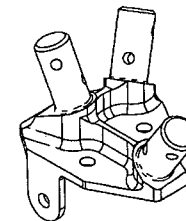
B55201

B50740

B54876

B54872

REFERENCE ON



RELEASED
2009-09-22

D3687-1 MOUNT

NOTES:

- 1) MATERIAL: 17-4PH SS BAR PER AMS 5643, H-900 CONDITION
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.81 lb
- 8) LPI PER QSI 038 4.1.1 (ASTM E1417 LEVEL 2)

C	0.555 WAS 0.50 (ZN B8-1); 1.373 WAS 1.375 (ZN A8-1, A8-2); ADD 0.620 (ZN B7-1) PER NCR09-084; UPDATE NOTE 8 TO REF QSI (ZN A6-1, B3-2); Ø0.257 WAS Ø0.250 (ZN A6-1, B7-1, B7-2)	RF	09.08.26
B	CHANGE TO 17-4PH H-900 (ZN A6-1 & B3-2); R0.032 WAS R0.015 (ZN C7-1 & C7-2); REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.03.12
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	GP		
MFG. APPR.	21		
APPROVED	16		
DE APPR.	16		
DATE	09.08.26		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3687 TITLE MOUNT SCALE NTS REV. C SHEET 1 OF 2 <small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			



LIQUID PENETRANT TEST REPORT

P- 15201

CLIENT	DACT Aerospace	DATE	JAN. 10. 2011	PAGE	1	OF	1	
ATTENTION	LINDA LACELLE	ACUREN JOB No.	188-11-2008	TIME	AM	<input checked="" type="checkbox"/>	PM	<input type="checkbox"/>
ADDRESS	1230 ABERDEEN ST HAWKESBURY, ON.	PO/VO No.		WORK LOCATION	HAWKESBURY PLANT			
PROJECT	F.P.I.	ACCEPTANCE STD.	ASTM 1417	REV./DATE	2005			
ITEM(S) EXAMINED	6 CROSS TUBES 2 ENGINE MOUNTS							

JOB DESCRIPTION	PROCEDURE No. LT-001 REV./DATE 2008	TECHNIQUE No. LT-002 REV./DATE 2008
PART No.	MATERIAL ALUMINUM THICKNESS VARIOUS	
SCOPE	WET FLUORESCENT LIQUID PENETRANT INSPECTION COPIED OUT 100% EXTERNAL	

TEST DETAILS	
METHOD <input checked="" type="checkbox"/> FLUORESCENT <input type="checkbox"/> VISIBLE	<input checked="" type="checkbox"/> WATER WASH <input type="checkbox"/> SOLVENT REMOVABLE <input type="checkbox"/> POST EMULSIFIED
FAMILY BRAND Maina Flux	BLACK LIGHT S/N 13454 <input type="checkbox"/> OUTPUT > 1000 μ W/cm ² <input type="checkbox"/> AMBIENT < 2 fc
PENETRANT 2LG7 MINIMUM DWELL TIME 45 10 MIN.	LIGHTING EQUIP. <input type="checkbox"/> FLASHLIGHT <input type="checkbox"/> TROUBLELIGHT <input type="checkbox"/> OUTPUT > 100 fc @ SURFACE
PENETRANT REMOVER H2O MINIMUM DRY TIME >10 MIN.	OTHER LAB. NO.
DEVELOPER SADS2 MINIMUM DWELL TIME 10 MIN.	LIGHT METER S/N 1098866
DEVELOPER TYPE <input checked="" type="checkbox"/> NON AQUEOUS <input type="checkbox"/> AQUEOUS <input type="checkbox"/> DRY	CAL DUE DATE 06-19-2011

TEST SURFACE	
SURFACE CONDITION <input type="checkbox"/> AS GROUND <input type="checkbox"/> AS WELDED <input type="checkbox"/> MACHINED <input type="checkbox"/> SHOT BLASTED <input type="checkbox"/> CLEAN BARE METAL	
SURFACE TEMPERATURE <input type="checkbox"/> < -4°C/ 20°F <input type="checkbox"/> -4°C/ 20°F TO 10°C/50°F <input type="checkbox"/> 10°C/50°F TO 52°C/125°F <input type="checkbox"/> > 52°C/125°F	

RESULTS- (<input type="checkbox"/> METRIC <input type="checkbox"/> IMPERIAL)	
1 - CROSS TUBE - W.C. 63783 ✓	
1 - CROSS TUBE - W.C. 63784 ✓	
1 - CROSS TUBE - W.C. 63523 ✓	
1 - CROSS TUBE - W.C. 63524 ✓	
1 - CROSS TUBE - W.C. 64541 ✓	
1 - CROSS TUBE - W.C. 64547 ✓	
1 - ENGINE MOUNT - W.C. 63456 + D3687-1 ✓	
1 - ADD D3687-3 ✓	

Scope of Services
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In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES	
CLIENT REPRESENTATIVE	PRINT SIGNATURE
TECHNICIAN (SIGNATURE):	REPORT REVIEWED BY:
NAME (PRINT):	NAME INITIALS
CGSB LEVEL 1 ST TECHNICIAN	CGSB LEVEL 2 ND TECHNICIAN
CGSB REG. No.	CGSB REG. No.